

STAR PARTS

QUADDER
OPERATOR'S MANUAL

STAR PARTS CO.
SOUTH HACKENSACK, NEW JERSEY

A DIVISION OF POWERS & EATON *Industries, Inc.*



SELECTRO-MATIC QUADDER OPERATORS MANUAL

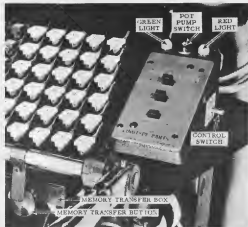
THE SELECTOR

Three buttons on the Selector Box cover all the operations for quadded and justified lines. Push the RIGHT or LEFT button for right or left flush, and CENTER for centered lines. All full lines will justify automatically in any of these positions.

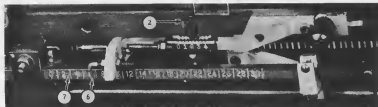
RECASTING

When you occasionally wish to recast a line, lock out the transfer levers in the usual way. Then push the Memory Transfer Button (see illustration) on the Memory Transfer Box and pull the clutch handle.

For longer recasting runs, set the Control Switch in the "Recast" position before sending the line in for casting. When the recasting run has been completed, remember to throw the Control Switch either to "Just" or to "Quad".



THE SHORT LINE DEVICE



The Star Selectro-Matic Quadder is provided with an automatic quadding feature for short lines. That is, lines that are less than full by a pre-set distance will automatically flush left, center, or flush right, depending on the Selector button you have pushed in at the time. (When setting straight matter the Selector is placed in "Left Flush" position). The distance is adjusted from 0 to 4 picas (see photo), depending on the length of line.

You adjust the distance by this simple rule: On short measures use the lower num-

bered settings; on long measures the higher numbers are used.

For instance, if you are setting lines which range from 4 picas to 12 picas in length, you would set the Indicator Adjusting Knob (2) at 1½ on the scale. As the line fills out in the assembler, the red pointer (6) over the Assembler Slide Indicating Bar (7) moves to the left. When this pointer reaches the number 1½ on the scale the line will justify.

If the pointer does not reach this point, the line will automatically flush left.

JUSTIFIED LINES

If you wish justified lines only, put the Control Switch on the side of the Selector Box in "Just" position. This puts the Quadder completely out of action, including the Short Line Device.

Even though the line may appear to be full, justified lines may fail to cast if spacebands are not clean, or if there are not enough of them in the line. As on any machine without a quadder, these are considered "loose lines", and the very efficient Electro Pump Stop Safety takes over to prevent squirts.

SIGNAL LIGHTS

There are two signal lights on the top of the Selector Box as illustrated.

GREEN

Goes on when the Control Switch is in either "Quad" or "Recast" position.

RED

Goes on only when line casts.

If the green light fails to show, though the switch is in "Quad" or "Recast" position, it will indicate that a bulb is out, or that something else is wrong. In the latter case refer to the Maintenance Manual.

The same is true of the red light, if it fails to show when the vise jaws close for a cast, providing Pump Stop Switch is in "ON" position.

SETTING MEASURES

The Measure Control Dial on the machines without Mohr Saws moves the assembler slide and vise jaw two picas to every turn.

On machines with Mohr Saws the Measure Control is synchronized with the saw and moves one pica to every complete turn of the dial.

Both set measures to points.

When turning dial to a new, **shorter** measure, turn it past the desired measure, then back to it. For instance, when changing from 15 to 10 picas, turn the dial from 15 to 9, then back to 10 picas.

When changing to a longer measure, say from 10 to 15 picas, simply turn up to 15, and no further.

CORRECTING SIGNALS

When you push a Selector Button and raise the assembling elevator even part way, you have sent a signal into a Master Control Box Relay.

If you should send the assembling elevator up part way, and then bring it down again to change to another signal on the Selector, you may get a quadded line not wanted. For example; you raise the elevator on a "Right Flush" signal. You change your mind when the elevator is part way up, let it down, and push the "Left Flush" button to get the operation you really wanted. The result will be a centered line, because both signals went into the relays.

To clear the relays when an incorrect signal has been transmitted, move the Control Switch to "Just" and then back again. The relays in the Memory Control Box will then have returned to open position, ready to receive the correct signal.

LUBRICATION AND MAINTENANCE

This subject is covered in your Maintenance Manual.

CAUTION: Be sure to turn off the Quadder, by means of the switch on the side of the Master Control Box in back of the machine, at the end of the shift. Otherwise the transformer will remain energized and the indicator light will remain on. This, of course, will shorten their life unnecessarily.

This Manual set in 10 point Star News with Bold



